

Work Order ID 145889

Friday, May 06, 2016 10:52:46 AM

145889Qty 1 to ship May 31
Qty 2 more in June - Page 1

Item ID: D3589-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Latch Assembly

Start Date: 4/28/2016 Start Qty: 6.00

Required Date: 5/5/2016 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3589

C

100

0.00

100

Large Fab

Large Fab

Memo

7.44

1- Form D3589-11, assemble and weld D3589-9 to D3589-11 as per dwg D3589

2- grind weld flush as per dwg D3589

3- slide (4) D3589-3 Arm Guides on D3589-1 Arm and weld D3589-13 lugs on both ends as per dwg D3589

*** ensure that the 4 ARM GUIDES are on the ARM before welding both LUGS***

4- using DT9033 jig install parts on door and weld as per dwg D3589 QSI004

ensure parts fit correctly on jig

A/R Stainless Steel Rod Batch: 123825

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

⑤ 16-05-30

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									

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5

DAS
38
9-89
MAY 31 2016

DQA: _____ Date: _____



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Work Order update only ☐

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OTHER : _____											

145889

Friday, May 06, 2016 10:52:46 AM

N900040100

Setup Start *NS1*

Stop *NS2*

6

6

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

150 Identify as per dwg & Stock Location: 54

0.00

150

Packaging Memo

0.06

Packaging

5 DAS
6
9-89

~~MAY 31 2016~~

160	QC21- Final Inspection - Work Order Release	0.00
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160

QC Memo

0.60

Quality Control

MUS

MAY 31 2016

MCK MAY 31 2016

DQA: _____ Date: _____



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OTHER : ☐											

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145889

D3589-041

Required Date: 5/5/2016

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002 746025	4	
144461	4	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002 145405	2	3
137595	2	2

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002	28	
139003	28	10

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002 144658	1	9
137072	1	1

DQA: _____ Date: _____



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Picklist Print

Friday, May 06, 2016 10:52:45 AM

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Work Order ID: 145889

145889

Parent Item: D3589-041

D3589-041

Parent Item Name: Latch Assembly

Start Date: 4/28/2016

Required Date: 5/5/2016

Start Qty: 6.00

Required Qty: 6.00

D3589-7 Manufactured No

100 Each 4.0000 1 6

D3589-7

Aft Guide Plate

**

16-05-26

JBL

Location

Loc Qty

Loc Code

WA002

4

139504

4

D3589-9 Manufactured No

100 Each 0.0000 1 6

D3589-9

Fwd Guide Plate

**

16-05-26

JBL

D3589-15 Manufactured No

130 Each 31.0000 2 12

D3589-15

Link

**

FF

MAY 30 2016

Location

Loc Qty

Loc Code

WA002

31

137716

31

D3589-3 Manufactured No

130 Each 27.0000 2 12

D3589-3

Arm Guide

**

~~MAY 30 2016~~

16-05-26

JBL

Location

Loc Qty

Loc Code

WA

27

144462

27

MS20392-1C7 Purchased No

130 Each 100.0000 2 12

MS20392-1C7

Pin

**

FF

MAY 30 2016

Location

Loc Qty

Loc Code

ST314

100

m134488

100

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Picklist Print

Page 3

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Parent Item: D3589-041

D3589-041

Parent Item Name: Latch Assembly

Start Date: 4/28/2016

Required Date: 5/5/2016

Start Qty: 6.00

Required Qty: 6.00

MS24665-1010

Purchased

No

130

Each

208.0000

2

12

MS24665-1010

COTTER PIN

**

FF

MAY 30 2016

Location

Loc Qty

Loc Code

ST288

208

108335

192

114405

16

10

NAS1149DN432J

Purchased

No

130

Each

165.0000

4

24

NAS1149DN432.J

WASHER

**

FF

MAY 30 2016

Location

Loc Qty

Loc Code

CA

165

m129682

165

20

Friday, May 06, 2016 10:52:45 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____

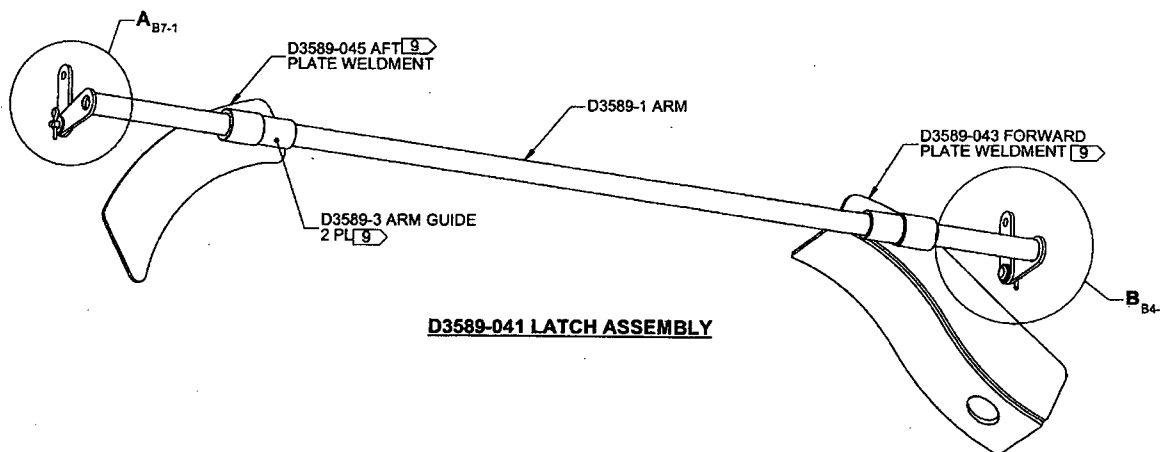


WORK ORDER NON-CONFORMANCE / UPDATE

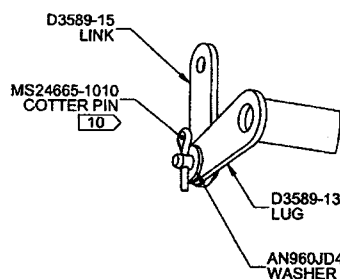
QA Closed: _____ Date: _____

Work Order update only ☐

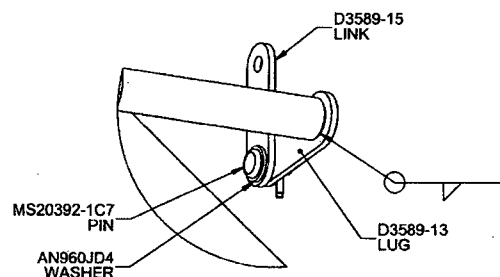
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							



D3589-041 LATCH ASSEMBLY



DETAIL A: LINK ASSEMBLY DETAIL
SCALE 2X
2 PL D8-1



DETAIL B: WELDING AND LINK ASSEMBLY DETAIL
SCALE 2X
2 PL C3-1

D3589-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.75 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
- 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

ITEM	QTY.	P/N	DESCRIPTION
	X	D3589-041	LATCH ASSEMBLY
1	1	D3589-043	FORWARD PLATE WELDMENT
2	1	D3589-045	AFT PLATE WELDMENT
3	1	D3589-1	ARM
4	2	D3589-3	ARM GUIDE
5	2	D3589-13	LUG
6	2	D3589-15	LINK
7	4	AN960JD4	WASHER
8	2	MS20392-1C7	PIN
9	2	MS24665-1010	COTTER PIN

WFO 145889

RELEASED
R 2012-07-16

C	REVISED D3589-5; 2.75 WAS 3.00 (ZN B6-4); ADDED D3589-21 (ZN B3-4); AFFECTS D3589-047 (ZN A7-3) AND D3589-048 (ZN A3-3). REVISED D3589-15: Ø0.140 WAS Ø0.125 (ZN B4-7). 0.900 WAS 1.150 (ZN C4-7); ADDED D3589-23 (ZN C3-4); AFFECTS D3589-043/045 (ZN D7-2 AND D2-2). REASON: PAR12-177.	MB	12.07.04
B	0.90 AND 0.63 REF WERE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 28" WAS 15" (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-8 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	1		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.07.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. C
D3589
SHEET 1 OF 8
TITLE
LATCH ASSEMBLY
SCALE
NTS

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								